

Work Order ID 55726

January 29, 2010 8:22:39 AM



Page 1

Item ID: D2055

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 1/28/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *H*

Date: *10-1-29*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2055	Rev C1

100

0.00



Hardinge CNC LATHE SMALL

0.00

Hardinge

Memo

Hardinge CNC Lathe Small

Machine as per Folio FA203
deburr all sharp edges as per dwg

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

SA 10/01/31

15

SA 10/01/31

15

SA 10/02/01

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo Drill hole as per dwg D2055	0.00 0.00	SA	10/02/01		15	✓		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	SD	10/02/01		19			
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	BF	10-02-01		19	✓		

Dart Aerospace Ltd

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Required Date: 2/08/10

Req'd Qty: 10.00



Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M105642

0.00

0.00

=> 10/02/02

(19) 0

Memo

START TIME:

2:00pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:30pm

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

bk 1002-2

(19) 0

Memo

180



Packaging

Packaging

Identify as per dwg & Stock Location:

5

0.00

0.00

Memo

11/02/03 (19)

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/04
MF 10-2-3

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Picklist Print

January 29, 2010 8:22:43 AM

Page 1

Work Order ID: 55726



Parent Item: D2055



Parent Item Name: Clamp

Start Date: 1/28/10

Required Date: 2/08/10

Comments: IPP C002.03.07 Now turned in house NG

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R1.000		Purchased	No			120	f	54.8524	1.0968			



ROUND BAR 1.00"

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	54.8524	
108876	8.355	
110966	11.6274	
113457	34.87	

1.824 SA 10/01/37

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DESIGN JB		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE		APPROVED [Signature]		DRAWING NO. D2055	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE CLAMP		SCALE 2:1	
A	92.03.13		NEW ISSUE		
B	98.10.15		0.191 DIA WAS 0.187 DIA (TSR A1100) REDRAWN, ADD FINISH		
C	98.12.10		ADDED 0.750 O.D. DIMENSION		
CI	CP	01.06.05	MODIFY HOLE SIZE, ADD P/C OPTION		

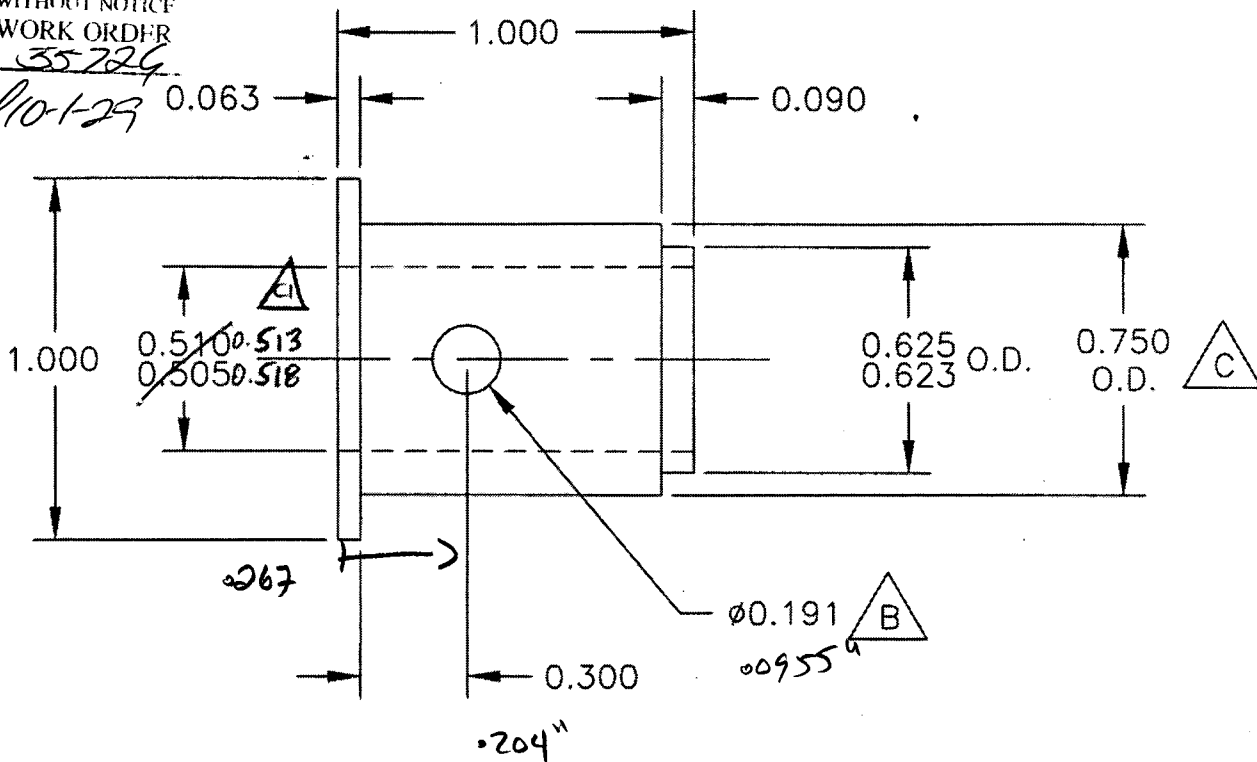
RELEASED
98.12.10 KE

ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 35724

BL10-129



ACID ETCH & ALODINE PER
DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7)
PER DART QSI 005 4.3

MATERIAL: 6061-T6 ROD (QQ-A-225/8)
FINISH: BLACK ANODIZE OR
BREAK ALL SHARP EDGES 0.015 MAX
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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